

Date: Friday, 5/25/2007 8:01:36 AM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	ARM
Job Number	32549			
Estimate Number	10705			
P.O. Number	N/A		Part Number	D2012101
This Issue	5/25/2007	S.O. No.	Drawing Number	D2012-101 REV C
Prsht Rev.	NC		Project Number	N/A
First Issue	N/A	Type	Drawing Revision	C
Previous Run	31481		Material	N/A
Written By			Due Date	6/5/2007
Checked & Approved By	<i>HJ 07.05.28</i>		Qty:	10
Comment	Est Rev: 02.04.03 Added Inspect level 3 NG		Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M304TR0500W035	304 RD Tube .500 x .035W	
		Comment: Qty.: 2.1000 f(s)/Unit Total : 21.0000 f(s) Material: 304/316 Seamless SS tubing, 1/2" O.D. x .035" wall(M304TR0.500W.035) Identify as D2012-101 Batch: <i>M 104640 (bx) / M 104598 (bx)</i>	<i>FF 07-06-26</i>
2.0	BRAKE NC	NC BRAKE	
		Comment: NC BRAKE	<i>(PTU)</i>
		1-Punch to length as per Dwg D2012-101 & template D2012-101T1	<i>FF 07-06-26</i>
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: SMALL & MEDIUM FAB RESOURCE 1	
		1-Deburr	<i>SAD 07/07/05</i>
4.0	QC5	INSPECT WORK TO CURRENT STEP	
		Comment: INSPECT WORK TO CURRENT STEP	<i>in 07/07/05 (49)</i>
5.0	POWDER COATING	POWDER COATING	
		Comment: POWDER COATING	
		Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3	<i>BL/FK 07-07-09</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

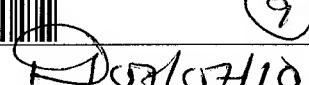
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/07/05
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/07/05	2.0	1 part is 90° under 30°. R.C: Material turned during anchoring.	<input checked="" type="checkbox"/> Qdulz	cut off the punch on one end. Identify material & re-stock per a shorter stut. No replacement.	8/5 07/07/05	Er 07/07/05	<input checked="" type="checkbox"/> ascan	<input checked="" type="checkbox"/> 07/05

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: ARM
Job Number: 32549		Part Number: D2012101
Job Number:		
Seq. #:	Machine Or Operation:	Description :
6.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION 
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION		
7.0	PACKAGING 1	PACKAGING RESOURCE #1 
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: _____		
8.0	QC21	FINAL INSPECTION/W/O RELEASE 
Comment: FINAL INSPECTION/W/O RELEASE		 ⑨
Job Completion		 C 5/25/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2012-101
DATE		SHEET 1 OF 1
02.03.26		SCALE NTS
A	92.06.04	NEW ISSUE - DRAWN FROM D2012
B	98.04.28	ADDED TEMPLATE & SPEC CTRL DWG REDRAWN IN CAD
C	02.03.26	ADD FINISH; CHANGE ANGLE TO MATCH B15015. PER NCR 641

RELEASED

02-03-26

A

ARM

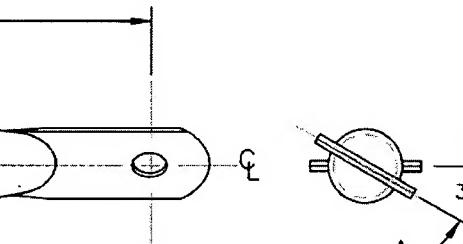
92.06.04

NEW ISSUE - DRAWN FROM D2012

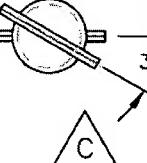
98.04.28

ADDED TEMPLATE & SPEC CTRL DWG
REDRAWN IN CAD

02.03.26

ADD FINISH; CHANGE ANGLE TO MATCH
B15015. PER NCR 641

C



C



C

NOTES:

1. MAKE PER TEMPLATE DT8067. (WAS DT2012-101)
2. MATERIAL: AISI 304/316 STAINLESS STEEL TUBE $\varnothing 0.500 \times 0.035$ WALL
3. FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
4. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5. ALL DIMENSIONS ARE IN INCHES

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RETURN TO

ENGINEERING

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SUBJECT TO AMENDMENT
WITHOUT NOTICEWORK ORDER # 32349